

Work Order ID 83006

Thursday, April 12, 2012 11:17:14 AM

Duplicate
83006

Page 1

Item ID: D3808-1

Revision ID:

Item Name: Seat Rail

Start Date: 4/12/2012 Start Qty: 4.00

Required Date: 4/24/2012 Req'd Qty: 4.00

Reference:

Defect 85504
N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan: *[Signature]*

Date: *12-04-12*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3808	Rev A

100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 16.125 " long								

110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA771 Rev: <i>AA</i> & Dwg D3808 Rev: <i>A</i> 2-Tap holes for 8-32" Helicoil 3-Tap holes for 3/8-16 Helicoil 4-Deburr per dwg D3808								

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

MS2120C 815
MS219C 610
M119316
M108847
4

W/O: 83006		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3808-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: At Date: 12/06/01
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/6/12

NCR: 12-1498		WORK ORDER NON-CONFORMANCE (NCR) PI. 37						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/08	110	Part off center due to origin. Operator error	S as per checkbox	Scrap + destroy wheel + Replace M 121040	PO 12/06/08	and 12/06/09	S as per checkbox	S 12/6/08

NOTE: Date & initial all entries

83006

Thursday, April 12, 2012 11:17:14 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/12/2012 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 4/24/2012 **Req'd Qty:** 4.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

130

enl 12/06/09

QC

Memo

0.00

Quality Control

0.00

140

4 26 12.6.11

HandFinish

Memo

0.00

Hand Finishing

0.00

141

4 of BR 12.6-11

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 12, 2012 11:17:19 AM

Page 1

Work Order ID: 83006

83006

Parent Item: D3808-1

D3808-1

Parent Item Name: Seat Rail

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	19.5933	1.35	5.684211			

M6061T6B2 000X01 250

6061-T6 Bar 2.00 x 1.25

**

PO

12/06/04

Location

Loc Qty

Loc Code

MAT009

7.59326358

114899

4.15263158

116623

2.15

119136

1.290632

MAT010

12

→

121040

12

5.7 + 1.35 PO 12/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	88006
Description: Seat Rail		Part Number:	D3808-1
Inspection Dwg: D3808	Rev: A	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	13.997	✓		Height gauge	
7.30	+/-0.030	7.300	✓		VERN	CAC-02
0.550	+/-0.010	0.546	✓		VERN	PHD-01
0.85	+/-0.030	0.852	✓		"	"
0.780	+/-0.010	0.784	✓		"	"
Ø0.391	+0.006/-0.001	0.391	✓		"	"
3/8-16 UNC	N/A	3/8-16 UNC	✓		REF	
Ø0.323	+0.006/-0.001	0.324	✓		VERN	PHD-01
Ø0.695 x 100°	+/-0.010 x 0.5°	0.695	✓		"	CNC-02
Ø0.172	+0.005/-0.001	0.172	✓		"	PHD-01
8-32 UNC	N/A	8-32 UNC	✓		REF	
0.800 x 0.667 deep	+/-0.010	0.800 x 0.667	✓		VERN	PHD-01
2.00	+/-0.030	2.010	✓		"	"
R0.26	+/-0.030	0.260	✓		Rad gauge	
6.13	+/-0.030	6.123	✓		VERN	CNC-02
5.13	+/-0.030	5.123	✓		"	"
0.16	+/-0.030	0.157	✓		"	PHD-01
1.75	+/-0.030	1.751	✓		"	"
15.88	+/-0.030	15.880	✓		HASS-3	
0.965	+/-0.010	0.964	✓		VERN	PHD-01
0.375	+/-0.010	0.373	✓		"	"
1.10	+/-0.030	1.101	✓		"	"
0.140	+/-0.010	0.144	✓		MIC	GA-03
0.373	+/-0.010	0.374	✓		"	"
0.030 x 45°	+/-0.010 x 0.5°	0.037	✓		VERN	PHD-01
R0.06	+/-0.030	0.060	✓		Rad gauge	
0.347	+/-0.010	0.344	✓		VERN	PHD-01
0.270	+0.030/-0.000	0.272	✓		MIC	PHD-09
Ø0.720	+0.005/-0.010	0.720	✓		VERN	PHD-01
R0.063	+/-0.010	0.063	✓		Rad gauge	
0.320	+0.020/-0.000	0.322	✓		VERN	PHD-01
R0.015	+/-0.010	0.015	✓		Rad gauge	
0.655	+0.015/-0.010	0.654	✓		VERN	PHD-01
0.350	+/-0.010	0.352	✓		"	"
0.030 x 45°	+/-0.010 x 0.5°	0.030	✓		"	"
0.667	+/-0.010	0.660	✓		"	"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD		Work Order:	83006
Description: Seat Rail		Part Number:	D3808-1
Inspection Dwg: D3808 Rev: A		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.156	+/-0.010	0.150	✓		VGRN	PHO-01
Ø0.695	+0.008/-0.001	0.695	✓		"	"
Ø0.323	+0.006/-0.001	0.324	✓		"	"
Ø0.800	+0.010/-0.001	0.800	✓		"	"
R0.031	+/-0.010	0.031	✓		Rad gauge	

Measured by: 70/da	Audited by: <i>anf</i>	Prototype Approval:	N/A
Date: 12/06/08	Date: 12/06/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

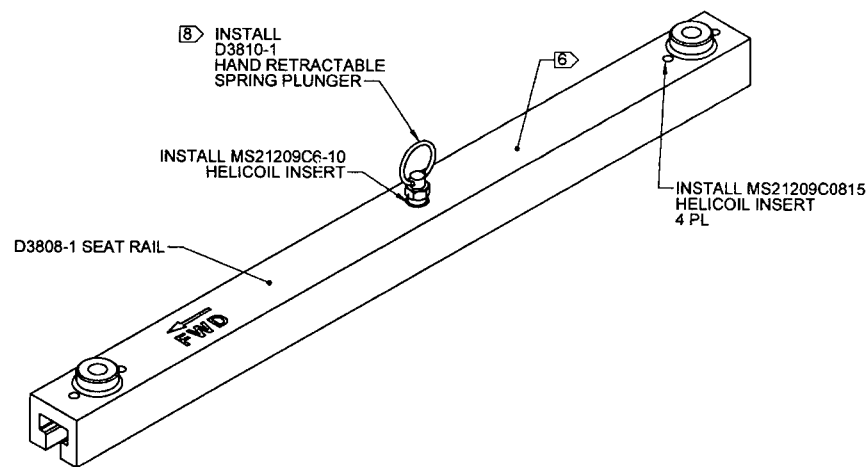
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83009

pl 12-04-12







D3808-041 SEAT RAIL ASSEMBLY

D3808-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3808-041 USING FINE POINT PERMANENT INK MARKER AS SHOWN
- 7) WEIGHT: 0.80 lbs
- 8) INSTALL D3810-1 INTO D3808-1 ONLY UNTIL NO THREADS VISIBLE ON D3810-1

QTY	P/N	DESCRIPTION
X	D3808-041	SEAT RAIL ASSY
1	D3808-1	SEAT RAIL
1	D3810-1	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C8-10	HELI-COIL, SCREW LOCKING (RED)
4	MS21209C0815	HELI-COIL, SCREW LOCKING (RED)

RELEASED
08-09-30-17

A	NEW ISSUE	RF	08.08.08	
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3808 TITLE SEAT RAIL ASSEMBLY COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	REV. A	
DRAWN	RF		SHEET 1 OF 2	
CHECKED			SCALE	
MFG. APPR.			NTS	
APPROVED				
DE APPR.				
DATE	08.08.08			

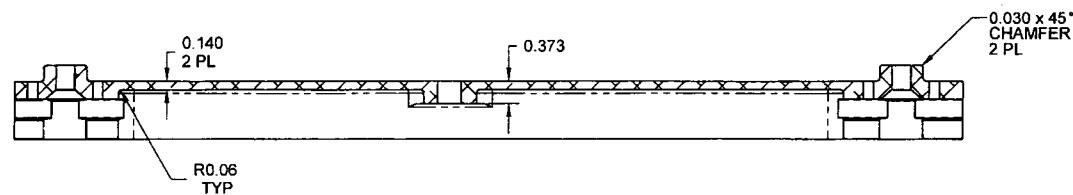
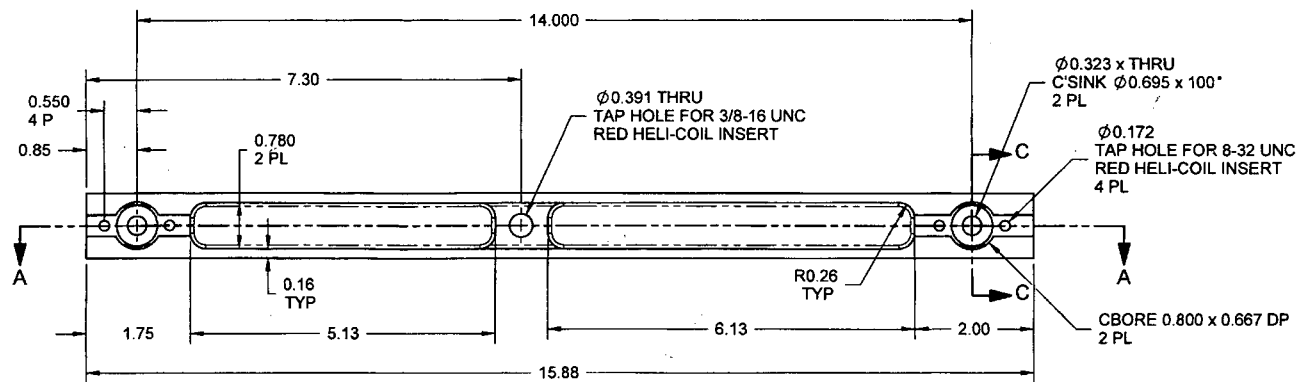
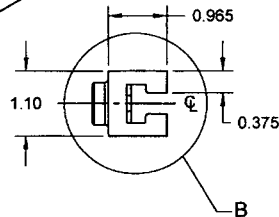
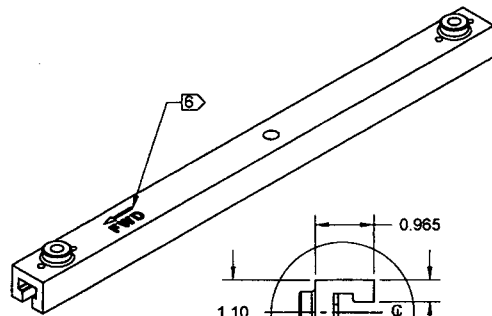
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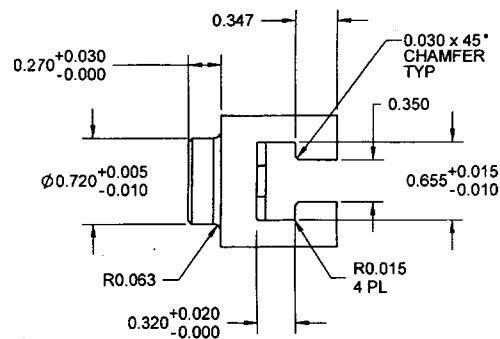
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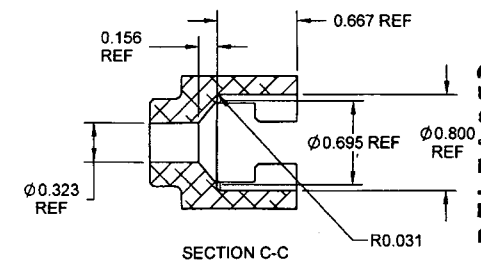
NOTE: Date & initial all entries



SECTION A-A



DETAIL VIEW B



SECTION C-C

8 3006

D3808-1 SEAT RAIL

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.30 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.768 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3808	REV. A
MFG. APPR.		TITLE SEAT RAIL ASSEMBLY	SCALE NTS
APPROVED		<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.			
DATE	08.08.08		

RELEASED

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